

SPLIT

Date: Thursday, 6/28/2007 9:50:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPAD
Job Number : 33243	
Estimate Number : 12781	
P.O. Number : N/A	Part Number : D35641
This Issue : 6/28/2007 S.O. No. : N/A	Drawing Number : D3564 UNDER REVIEW
Prsht Rev. : NC	Project Number : N/A
First Issue : 6/28/2007 Type : SMALL /MED FAB	Drawing Revision : A C RH 07.07.13
Previous Run : 31417	Material : N/A
Written By : <u>Hj 07.06.28</u>	Due Date : 7/10/2007 Qty: 20 Um: Each
Checked & Approved By : <u>Hj 07.06.28</u>	
Comment : Est Rev A New Issue 07-03-08 ec	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
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10	M304S16GA	304/316 063 Sheet
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Comment: Qty.: 0.9177 sf(s)/Unit Total : 18.3540 sf(s)
M304S16GA Stainless steel sheet 0.063" thick
Batch: M 103961 B 07-07-18

20	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3564 ***** (D3564-1F) *****
Dwg Rev: C
Prog Rev: C
2-Deburr if necessary

B 07-07-18

PFO →

30	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

40	QC8	SECOND CHECK
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Comment: SECOND CHECK

In 07/07/19 Y 20 control

50	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Deburr if necessary
Form on Brake as per Dwg D3564 using Jigs DT 8155 and DT 8179
Form Joggles (2) as per Dwg D3564 on brake using Jig DT

SAD
SAD 07/07/19 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: R Date: 07/07/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/19	20	1 part SCRAP distance from hole to outside LAB is too small 0.213" instead of 0.205" (0.0052") R.C. Part made during water	<i>[Signature]</i>	Scrap and Replace. Remind Employee to be more cautious when marking part on the water jet. <u>Bolt 101 813</u>	07-07-19	En 07/07/19	<i>[Signature]</i>	En 07/07/19
07/07/19	E	Setting 1 part SCRAP distance from hole to outside LAB is too small 0.213" instead of 0.205" (0.0052") R.C. Part made during water made by [unclear] 07/07/20						

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33243

Part Number: D35641

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

En 07/07/20 (420) *caution*

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description

Batch

A/R 2059B Hardcoat

Weld hardcoat as per Dwg D3437

M105258

M105258

88 07/07/25 (x9)

88 07/07/28 (11)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

07/07/30 (11) *caution*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/07/30 (11)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M 104846

m-l 07/08/03

(11X)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

F-X 07/08/07 (11)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FP-14

m-l 07/08/07

(11X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/08 (11)

Job Completion



07-08-07

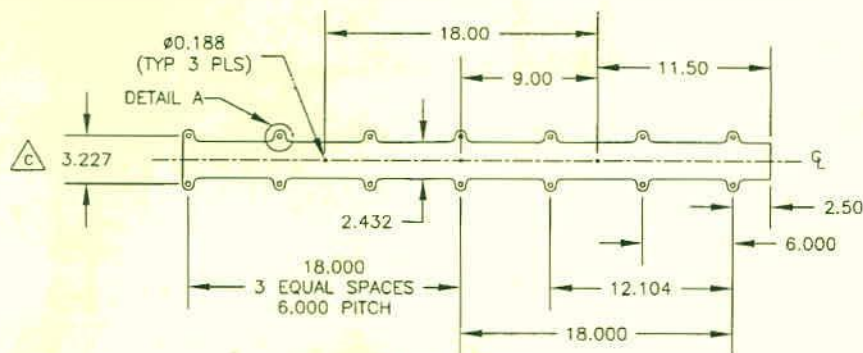
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

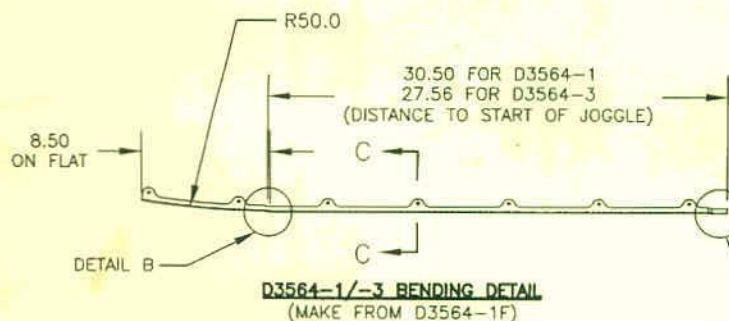
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

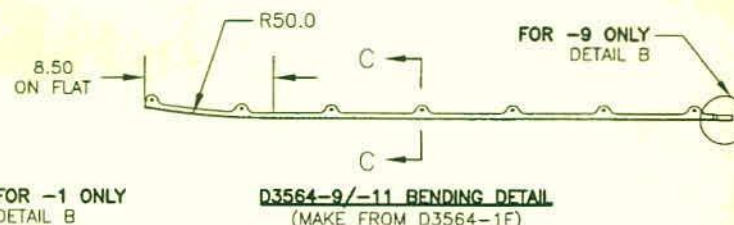
NOTE: Date & initial all entries



D3564-1F FLAT PATTERN

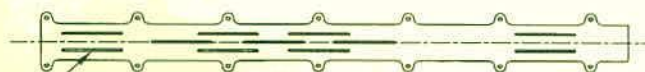


D3564-1/-3 BENDING DETAIL
(MAKE FROM D3564-1F)



D3564-9/-11 BENDING DETAIL
(MAKE FROM D3564-1F)

2059B HARDCOAT WELD
4.0 LONG
0.063 TO 0.125 HIGH
(TYP. 11 PLS.)
WELD AFTER BENDING AS
ILLUSTRATED PER DT8308



D3564-1/-3/-9/-11 WELDING DETAIL

RELEASED
07.04.17

D3564-1/-3/-5/-7/-9/-11/-13 WEARPLATE NOTES

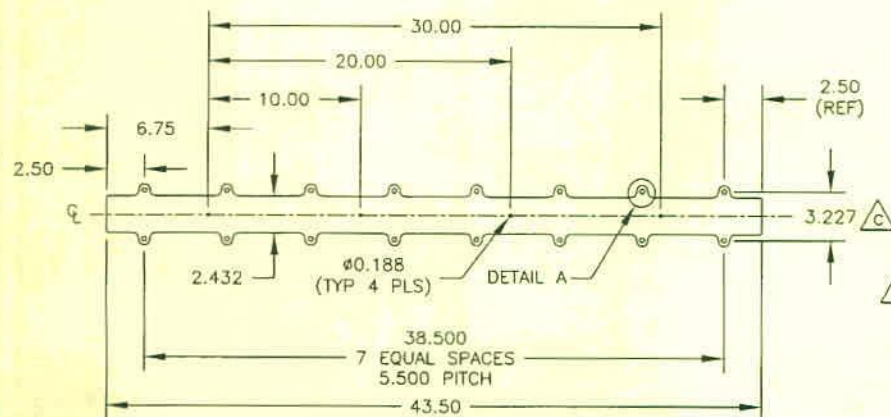
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART MATERIAL SPEC M304S16GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 7) PART IS SYMMETRICAL ABOUT CENTERLINE

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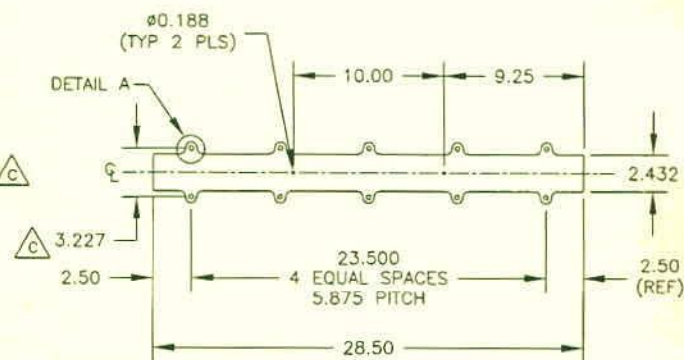
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C	07.04.17	MOVE TAB OUTBOARD, DETAIL A
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.12.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3564
DATE	TITLE	WEARSHOE
07.04.17		SCALE 1:8

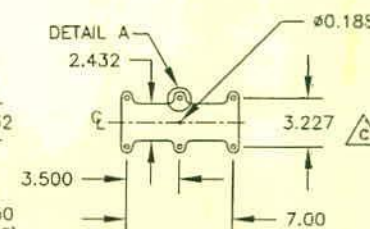
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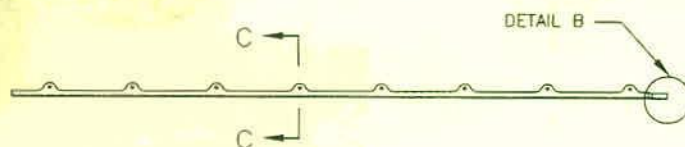
D3564-5F FLAT PATTERN



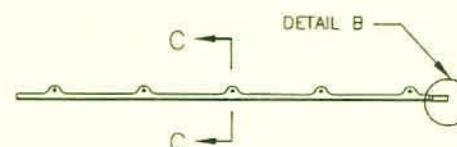
D3564-7F FLAT PATTERN



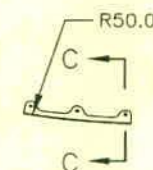
D3564-13F FLAT PATTERN



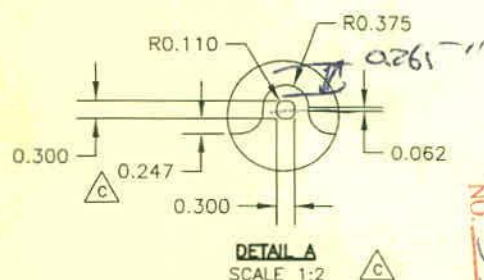
D3564-5 BENDING DETAIL
(MAKE D3564-5 FROM D3564-5F)



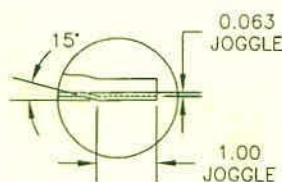
D3564-7 BENDING DETAIL
(MAKE D3564-7 FROM D3564-7F)



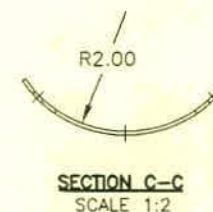
D3564-13 BENDING DETAIL
(MAKE D3564-13 FROM D3564-13F)



DETAIL A
SCALE 1:2



DETAIL B
SCALE 1:2



SECTION C-C
SCALE 1:2

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3564	REV. C
DATE	07.04.17	TITLE	WEARSHOE	SHEET 2 OF 2	SCALE 1:8

RELEASED
07.04.2017

